

Work Order ID 55075

January 5, 2010 3:02:58 PM



Page 1

Item ID: D4038-12

Accept



Setup Start



Revision ID:

Item Name: Aft Block, Aft, RH

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4038

A-PRELIM

100

0.00

Mill Conv

Memo

0.00

Conventional Milling Machine

Mill as per Dwg

MWF

10/01/07

PRELIMINARY ISSUE

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

MWF

10/01/07

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

10-01-07

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55075

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Item ID: D4038-12

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Block, Aft, RH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

10-01-7

1 1



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

10-01-07

1 1



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location

0.00

David S. C. Long

10-01-07



Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 55075

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Item ID: D4038-12 Accept Setup Start
Revision ID:
Item Name: Aft Block, Aft, RH Stop
Start Date: 05/01/2010 Start Qty: 1.00 Cust Item ID:
Required Date: 15/01/2010 Req'd Qty: 1.00 Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

RD0329A JAN
P/10-6-08
①

POSITIVE RECALL

EFFECTIVE 10-01-05 AUTH u

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 3:03:03 PM

Page 1

Work Order ID: 55075

Parent Item: D4038-12

Parent Item Name: Aft Block, Aft, RH

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purchase	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty Held	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	16.5683	0.1747			



6061-T6 Bar 1.50 x 2.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

16.5683

108877

0.4736

110167

16.0947

0.1747 DJT
10/01/06

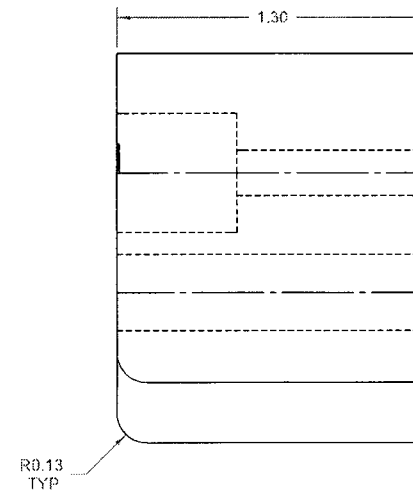
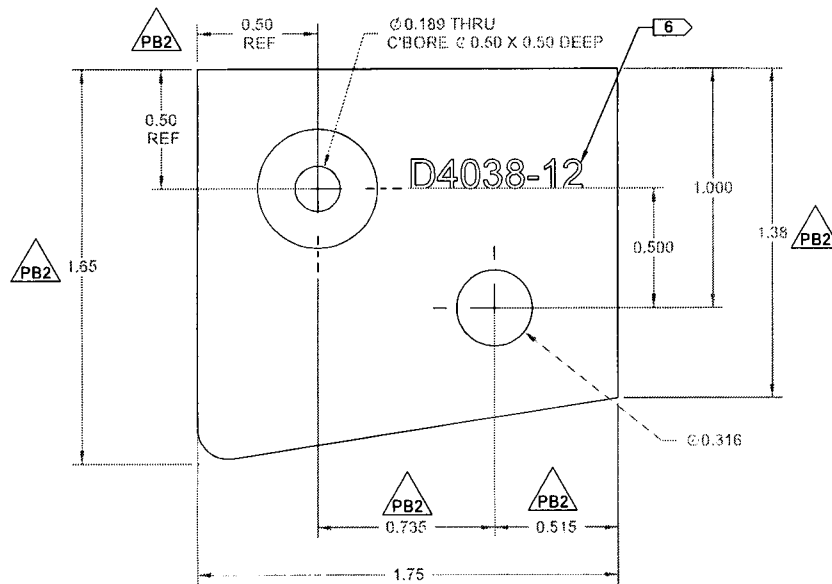
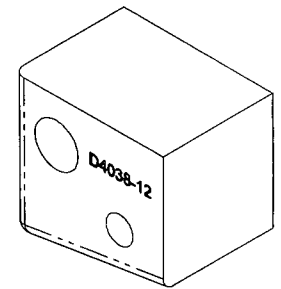
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NOTE: Date & initial all entries



D4038-12 BLOCK

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

PRELIMINARY ISSUE

10.01.05

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 10.01.05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4038

TITLE
BRACKET

REV. PB2
SHEET 14 OF 14
SCALE
NTS

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55075